

D6101-003



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200
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D2667-1

Job Sheet 214970



Part No: D2667-1

Job Qty: 4 pcs

Part Name: Saddle, LH, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/3/20

Job Tracking No:

Due Date: 12/4/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Machining - Issue SN	4 pcs	12/3/20	12/3/20	0.00	0.00	HAAS - 1		DIP 20-11-16
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
100	HAAS 4 Axis - B4B	4 pcs	12/3/20	12/3/20	1.00	6.96	HAAS - 1 - B4B	DAS 52	20/4/17
							HAAS - 2 - B4B	9-89	
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
110	Conventional Mill - 1 - B4B	4 pcs	12/3/20	12/3/20	0.00	6.96	Conventional Mill - 1 - B4B	DAS 52	20/11/17
							Conventional Mill - 2 - B4B	9-89	
120	QC 2	4 pcs	12/3/20	12/3/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Container No: S313403



Part: D2667-1

Job No: 214970

Serial No/Batch: S313403

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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https://www.plexonline.com/28164cf-be99-46a8-b291-020a4344bcf5/Plexus_Control/Report_View/Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=True... 2/4

				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 1 White GI(A)- B4B	4 pcs	12/4/20	0.00 0.22	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Powdercoat - 5 - B4B	
				Powdercoat - 6 - B4B	
				Powdercoat - 7 - B4B	
				Powdercoat - 8 - B4B	
				Powdercoat - 9 - B4B	
				Powdercoat - 10 - B4B	
160 QC 3	4 pcs	12/4/20	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
				QC 3 - 47	
170 Packaging 3-1 - Stock - B4B	4 ✓ pcs	12/4/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	

					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 37 - B4B	
					QC 21 - SA - 21	DAS 21 DEC 01 2020
					QC 21 - SA - 70	9-59
180 QC 21 - SA	4	12/4/20	0.00	0.00	QC 21 - SA - 9	
	pcs				QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - Program batch number. 1-Inspect part number and batch number are programmed correctly. 3-Fixturing Inspection
 Descriptions: last completed on _____ by _____ 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension
 Sheet 5-Machine Step No 2 of F
 110 - Machine Keyway and inspect per attached dimension sheet
 120 - QC2- Inspect parts off machine FAI/FAIB
 130 - QC8- Inspect parts - second check
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 160 - QC3- Inspect Part Finish
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	90-Machining - Issue SN	3X 5296733 1X 8312717

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-003	4	11	0

Part Specifications

Specifications could not be found.

Plex 11/3/20 1:09 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 214970
Description: 206 Saddle, Outboard, Left side		Part Number: D2667-1
Inspection Dwg: D2667 Rev: D DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		0.123	0.123	0.123	0.124	
B	0.100	0.140		0.129	0.131	0.130	0.130	
C	1.125	1.145		1.135	1.135	1.135	1.135	
D	0.615	0.685		0.660	0.660	0.660	0.660	
E	0.240	0.260		0.255	0.255	0.255	0.255	
F	1.313	1.343		1.326	1.326	1.326	1.326	
G	0.210	0.230		0.223	0.223	0.223	0.223	
H	0.100	0.180		0.140	0.140	0.140	0.140	
I	2.470	2.510		2.493	2.493	2.493	2.493	
J	1.565	1.585		1.575	1.575	1.575	1.575	
K	0.235	0.240		0.238	0.238	0.238	0.238	
L	0.100	0.120		0.114	0.113	0.113	0.113	
M	0.990	1.010		1.002	1.003	1.003	1.003	
N	0.510	0.515		0.512	0.512	0.512	0.512	
O	5.990	6.010		6.002	6.002	6.002	6.002	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.312	0.318		0.313	0.313	0.313	0.313	
S	0.315	0.322		0.316	0.316	0.316	0.316	
T	1.995	2.005		2.000	2.000	2.000	2.000	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.787	0.807		0.796	0.797	0.797	0.797	
W	1.040	1.060		1.050	1.050	1.050	1.050	
X	1.674	1.684		1.679	1.679	1.679	1.679	
Y	0.256	0.262		0.258	0.258	0.258	0.258	
Z	0.912	0.932		0.922	0.922	0.922	0.922	
AA	0.490	0.510		0.501	0.500	0.501	0.501	
AB	0.178	0.198		0.188	0.188	0.188	0.188	
AC								
AD								
AE								

DAS Accept/Reject

Measured by: 52	Date: 20/01/17
Audited by: 9-89	Date: 20/01/23
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.11	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Revised dimensions R and Y	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					